

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004974**Date Inspected:** 08-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Island, Shanghai

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower components		

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

Deck Panel DP603-001

1. The QA Inspector and QA Inspector Aaron Wintrich performed Ultrasonic Testing (UT) on the Partial Joint Penetration (PJP) welds made between the U-ribs (five ribs, two welds per rib ten total welds) and flat plate members of the assembly deck panel identified as DP603-001. The QA Inspectors performed the ultrasonic testing using the gate to gate method on the tack weld areas only a total of 200 tack welds were made on the ten welds. The QA Inspectors performed the testing on the weld number one through ten. The QA Inspectors observed several linear indications that appeared to be suspected planar discontinuities located at random locations on the welds and the indications were marked on the steel for Phased-Array Ultrasonic Testing (PAUT) investigation that will be performed at a later time. The observed indication's "Y" location was recorded into the QA Inspector's U-Rib to Deck Panel – Weld assessment sheet. The QA Inspectors used the ZPMC ultrasonic testing procedure identified as "UT 04-012024 PJP Rib Weld", Ultrasonic Testing for the Detection of Suspected Planar Discontinuities (Cracks) in PJP Welds for the evaluation of observed indications. The QA Inspectors completed the testing on the weld number one through ten on this shift. The QA Inspector notified Task Leader Albert Carreon of indications observed and the status of complete testing.

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Deck Panel DP602-001

2. The QA Inspector and QA Inspector Aaron Wintrich performed UT on the PJP welds made between the U-ribs (five ribs, two welds per rib ten total welds) and flat plate members of the assembly deck panel identified as DP602-001. The QA Inspectors performed the ultrasonic testing using the gate to gate method on the tack weld areas only a total of 90 tack welds were made on the ten welds. The QA Inspectors performed the testing on the weld number one through ten. The QA Inspectors observed several linear indications that appeared to be suspected planar discontinuities located at random locations on the welds and the indications were marked on the steel for PAUT investigation. The QA Inspectors used the ZPMC ultrasonic testing procedure identified as "UT 04-012024 PJP Rib Weld", Ultrasonic Testing for the Detection of Suspected Planar Discontinuities (Cracks) in PJP Welds for the evaluation of observed indications. The QA Inspectors completed the testing on the weld number one through ten on this shift. The QA Inspector notified Task Leader Albert Carreon of indications observed and the status of testing.

Summary of Conversations:

As noted in the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
